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D3859-041
Job Sheet 201548



Part No: D3859-041

Job Qty: 4 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/19

Job Tracking No:

Due Date: 10/31/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D3859 REV.C IPP Rev:A 09-02-03 new issue DD verified by:EC IPP Rev:B 14.04.30 as per dwg rev.b DD verified by:JLM IPP REV:C 17.11.17 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		10/31/19	0.17	0.61	Waterjet - Flow		2019/11/03
110	QC 2	4 pcs		10/31/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		2019/11/03
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S229149

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Part No: D3859-041

Job No: 201548

Serial No/Batch: S229149

Revision: C

Inspector:

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120 QC 8	4 pcs	10/31/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Large Fab - Welded Assy-2-B4B	4 pcs	10/31/19	0.00 6.78	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
135 Automated Welding - B4B	4 pcs	10/31/19	0.00 0.40	Large Fab - 11 - B4B (Various)	
				Automated Welding - 1 - B4B	
140 QC 9	4 pcs	10/31/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
150 QC 5	4 pcs	10/31/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	

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MV Nov 14/19

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				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	la
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180	Packaging 3-1 - Stock - B4B	4 pcs	10/31/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
190	QC 21 - SA	4 pcs	10/31/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - 1-Cut as per Dwg D3859-1 Dwg Rev: C Prog Rev: C 2-Deburr if necessary
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Weld per dwg A/R S.S. rod Batch: M136585 1-Weld D4379-5 cups as per dwg D3859 A/R 316L stainless steel rod *****use DT9462 for welding***** 2- WELD HARDCOAT TO BAR 2059B HARDCOAT BATCH: M131005 3- POLISH WELS SURFACE AREA AS PER DWG NOTE2
 135 - AUTO WELD HARDFACING 8259 BATCH: M139025
 140 - (QC9- Inspect visual per QSI004- Fusion Welds)
 150 - (QC5- Inspect part completeness to step on W/O)

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180 - (Identify as per dwg & Stock Location: _____)
190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	3.4000 sf (.85 ea)	100-Waterjet - Flow - 1	S207058
D4379-5	Wearplate Cup	24 pcs (6 ea)	130-Large Fab - Welded Assy-2- B4B	S280363

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	3	419	0
130-Large Fab - Welded Assy-2- B4B	D4379-5	24	248	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE** ☐ Route update only

NCR No. _____		Job: _____		Part No. _____	
DISPOSITION		DEPARTMENT/PROCESS			
Rework ☐		Eng. (Non-AW) ☐			
Scrap ☐		Prod. Eng. Coord. ☐			
Use-as-is ☐		Rec/Store/Packaging ☐			
Skid-tube ☐		Cross tube ☐			
Machining ☐		Small Fab ☐			
Large Fab ☐		Finishing ☐			
Engineering ☐		Water Jet ☐			
Supplier ☐		Quality ☐			
MRB (QS1042) ☐					
Sequence #: _____		QTY Affected: _____			
Date: _____		Disposition			
Description Work Order Deviation					
Completed By					
Lead hand / Supervisor					
QC / QA Coordinator					
Root Cause		FAULT CATEGORY			
Operator ☐		Power Loss/Surge ☐			
Manufacturing Process ☐		Folio/Program ☐			
Equip/Tooling ☐		Grain Direction ☐			
Handling/Preservation ☐		Weld ☐			
Material ☐		Wrong Stock Pulled ☐			
Product Improvement ☐		Out of Sequence ☐			
Process Improvement ☐		Off-set/Set-up ☐			
Human Factors ☐		Positioned Wrong ☐			
		Outside Tolerance ☐			
		Drawing ☐			
		Finish ☐			
		Part Lost/Missing ☐			
		Misread ☐			
Other/Details:					